

Date: Tuesday, 03/02/2009 2:49:05 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 45475
 Estimate Number : 13769
 P.O. Number :
 This Issue : 03/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3860041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3860 REV.A
 Previous Run : 45474 Drawing Revision : A
 Material :
 Due Date : 20/02/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JUD 09.02.03
 Comment : Est Rev:A 09-02-03 new issue DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.4780 sf(s)/Unit Total : 1.9118 sf(s)
 304/316 .063 Sheet
 Batch: 110551 AB 9-2-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3860
 Dwg Rev: A
 Prog Rev: A

AB 9-2-4

4

2-Deburr if necessary AB 9-2-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



AB 9-2-4



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5096105 (4)

5.0 D30093 Cup



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
 CUP
 Batch: B 42376 = 16x.

Sp 09.02.12.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/02/2009 2:49:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45475

Part Number: D3860041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3860

A/R 316L stainless steel rod

Batch:

M108775

EL/ SP 09-02-18

2-Weld hard facing as per Dwg D3860

A/R 2059B Hard Coat rod

Batch:

M109893

EL

9-2-19

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 09-02-20

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

209-02-20 (4)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15am

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:45am

9/02-02-23

(4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/23

(4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker as indicated on dwg, then Stock

Location:

SK PPD 45466

09/02/23 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24

MF 09-02-24

letion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

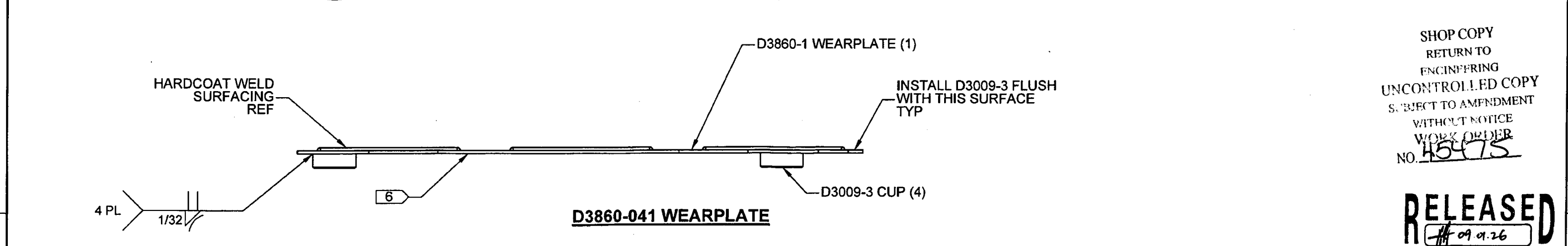
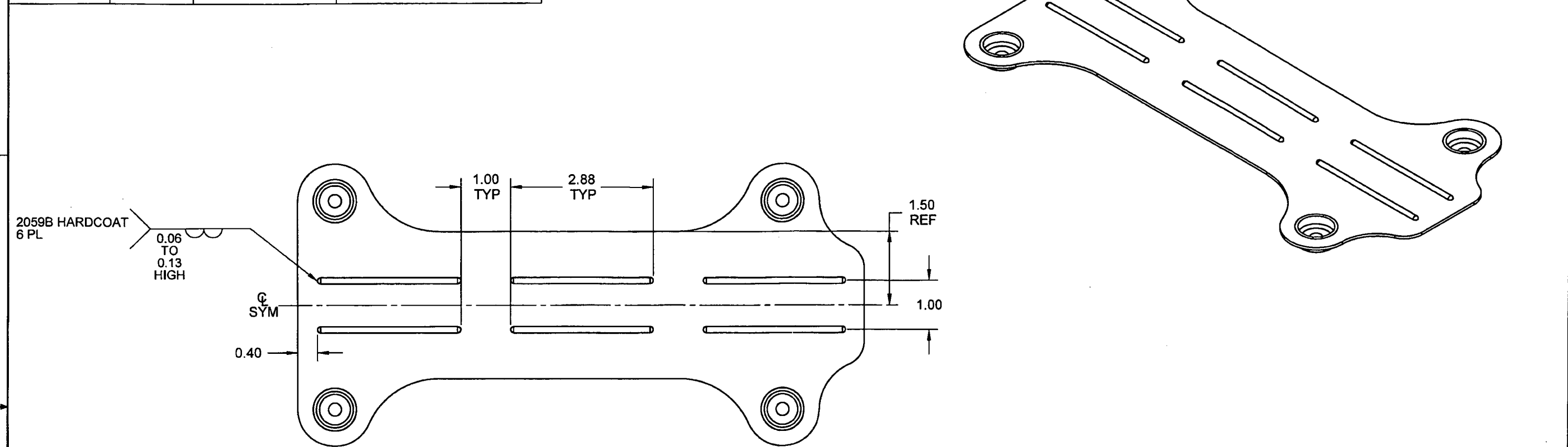
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3860-041	WEARPLATE
2	1	D3860-1	WEARPLATE
3	4	D3009-3	CUP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3860-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.87 lbs
- 8) WELD PER DART QSI 004

D3860-041 WEARPLATE

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WITHOUT NOTICE
WORK ORDER
NO. 45475

RELEASED
09.01.26

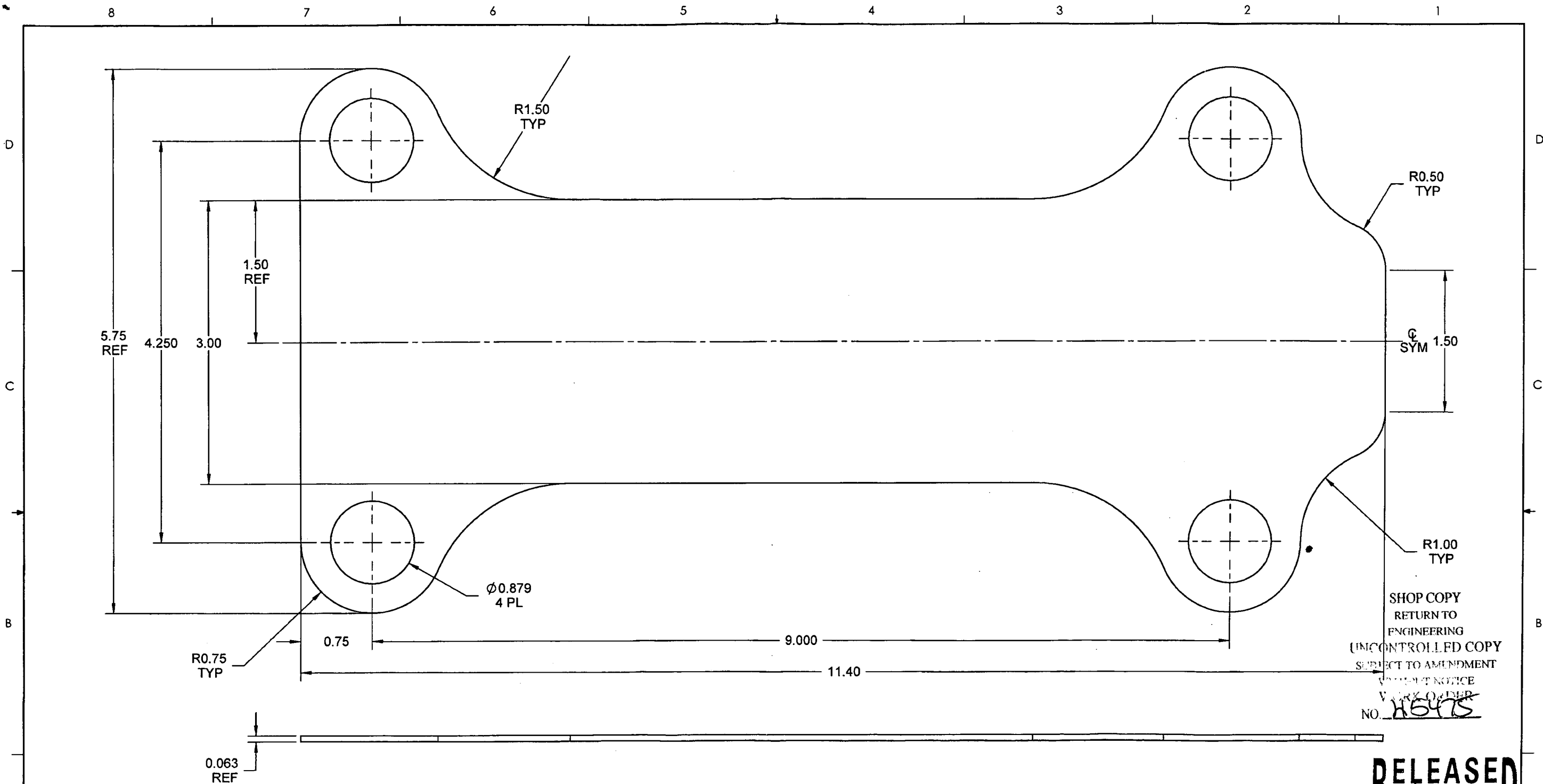
A	NEW ISSUE	BY	09.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3860** REV. A
SHEET 1 OF 2

TITLE **WEARPLATE** SCALE NTS

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WORK ORDER
NO. H5475

RELEASED
09-01-26

D3860-1 WEARPLATE

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.73 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3860	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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